



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBH9928-2
Job Sheet 182717



Part No: RBH9928-2

Job Qty: 10 ea

Part Name: Trim Tab Bender



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/30/18

Job Tracking No:

Due Date: 10/10/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBH9928-2 Rev K IPP Rev A 17.11.13 New Issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K DP
Verify DD IPP Rev.C 18.01.18 Updated process, all done under assy. JFS Verified by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		10/10/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	10 pcs		10/10/18	0.00	0.25	Bandsaw1		
110	Mori Seiki	10 pcs		10/10/18	0.00	5.00	MORI NV5000-1		
120	QC	10 pcs		10/10/18	0.00	0.00	QC2 Machining-5		
130	QC	10 pcs		10/10/18	0.00	0.00	QC8-7		
140	Brake NC	10 pcs		10/10/18	0.00	5.00	Brake NC 1		
155	QC	10 pcs		10/10/18	0.00	0.00	QC5		
165	Outsource	10 pcs		10/10/18			ATG001-VC		
175	Packaging	10 pcs		10/10/18	0.00	0.00	Packaging2		
180	QC	10 pcs		10/10/18	0.00	0.00	QC6		
190	Small Fab	10 pcs		10/10/18	0.00	5.00	Small Fab		
200	QC	10 pcs		10/10/18	0.00	0.00	QC5		
210	Packaging	10 pcs		10/10/18	0.00	0.00	Packaging3		
220	QC21-SA	10 Ea		10/10/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks to 8.00"

Descriptions: 110 - 1-Machine RBH9928-2-1 & RBH9928-2-3 as per folio FB676 FOLIO REV: 44 DWG REV:

2-Deburr NOTE; ***Machine both parts at same time***

130 - Engrave T/N number ONLY (RBH9928-2) using Marktronic engraver as per DWG.

140 - Form RBH9928-2-1 as per DWG. -Remove bending marks -Breach RBH9928-2-3 as per DWG. -Tumble to remove buffer marks

165 - Issue P/O to ATG : PO 041798 ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

190 - Assemble as per DWG. Sheet 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250X6.250	6061-T651 Sheet 0.250" Thick Plate x 6.250" Wide	6.6600 ft (.666 ea)	90-Start up Operation	5033401
92356A247	Carriage Bolt	24 20 Ea (2 ea)	190-Small Fab	5092860
96659A104	Washer	24 20 Ea (2 ea)	190-Small Fab	5011316
KKT-11A	Knurled Knob	24 20 Ea (2 ea)	190-Small Fab	5088956



Container No: S129521



Part: RBH9928-2

Job No: 182717

Serial No/Batch: S129521

Revision: K

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/20/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.250X6.250	7	9	0
190-Small Fab	92356A247	20	107	0
	96659A104	20	55	0
	KKT-11A	20	47	0

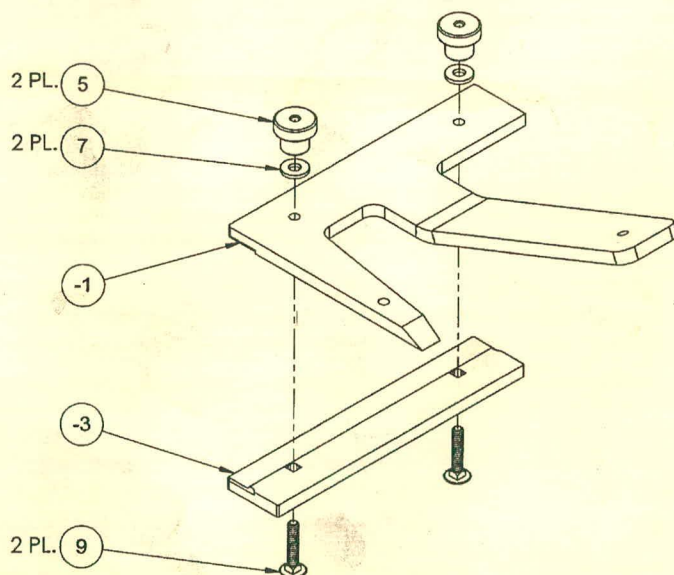
Part Specifications

Specifications could not be found.

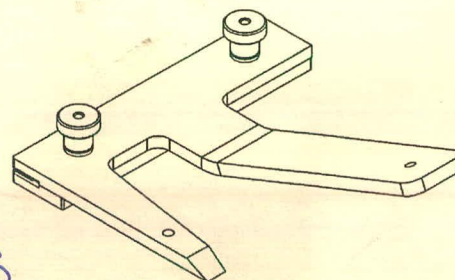
Plex 11/16/18 7:37 AM dart.lacelle.linda

ITEM #	QTY	PART #	TITLE	PG
-1	1	RBH9928-2-1	TAB BENDER	2
-3	1	RBH9928-2-3	CLAMP	3
5	2	ESSENTRA #KKT-11A	FEMALE KNOB KNURLED	-
7	2	McMaster#96659A104	# 10 STAINLESS STEEL SAE FLAT WASHER	-
9	2	McMaster#92356A247	SQUARE NECK CARRIAGE BOLT #10-24 X 1" LG.	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
9	SEPERATED FROM RBH9928	-	6/5/13	BIM	EB
10	-1 CH'D DISTANCE OF RADIUS FROM .500 (X2) TO .670 (X2). -3 CH'D DISTANCE OF RADIUS FROM .625 (X2) TO .670 (X2). CH'D NON-CRITICAL DIMENSION PRECISION FROM .XXX TO .XX.	-	7/31/13	RJC	GE
K	TEMPLATE UPDATED AS PER HAWKESBURY STANDARDS. -3 DRILL AND BROACH DIMENSION CHANGED. -1 & -3 RADIUS ALONG THE EDGE DIMENSIONS ADDED, TOLERANCE ADDED ON -1 & -3	17-669	17.09.22	VM	WM



RBH9928-2 TAB BENDER



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A/N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) USED IN ASSEMBLY RBH9982

DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE TAB BENDER			
DWG NO.		REV K	
DESIGN BY: VM 9/22/2017		XXX 2 .505 FRACTIONS & 1/8	
DRAWN BY: WM 11/15/2017		XX 2 .01 ANGLES & 5°	
CHECKED: WM 11/15/2017		X 2 .1 SURFACES & 12°	
MFG. APPR: DP 11/16/2017		1. DIMENSIONS ARE IN INCHES	
APPROVED: WM 11/16/2017		2. INTERPRET DIM AND TOL PER	
DATE: 11/15/2017		3. DIMENSIONAL LIMITS APPLY	
SCALE: NTS		WEIGHT: N/A	
		SHEET 1 OF 3	
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INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041798**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041798
PO Date: 11/21/18
Due Date: 11/29/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186256	646.3313	Upper Guide Issue P/O to ATG : Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	-	11/27/18	20 pcs	0 pcs	20 pcs	\$16.36/pcs	\$327.20
Line Item Note ** can we get the 20 pieces by the 27? **											
	185773			Firmed	-	11/29/18	4 pcs	0 pcs	4 pcs	\$16.36/pcs	\$65.44
Sub Total:							24	0	24		\$392.64
2	185326	D5046-047	Co-Pilot Collective Head Assembly : Various STC's Issue P/O to ATG: Black Anodize as per Dwg D5046 C OF C REQUIRED	Firmed	-	11/29/18	2 pcs	0 pcs	2 pcs	\$10.40/pcs	\$20.80
Line Item Note ** RUSH - would be great for Friday or latest Monday morning ** :)											
3	182717	RBH9928-2	Trim Tab Bender -Issue P/O to ATG : PO ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/29/18	12 pcs	0 pcs	12 pcs	\$10.40/pcs	\$124.80



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PURCHASE ORDER **PO041798**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	185416	D5274-1	Step Extrusion : Various STC's Receive & Inspect for Damage & Mat'l Certs Outsource process- Anodize per QSI017 4.1.10.1 ISSUE P/O TO ATG: ANODIZE BLACK AS PER DWG AND MIL SPEC C OF C IS REQUIRED	Firmed	-	11/29/18	1 pcs	0 pcs	1 pcs	\$58.26/pcs	\$58.26
5	186624	D5237-3	Bracket : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2 Certification of Conformity is required	Firmed	-	11/29/18	3 pcs	0 pcs	3 pcs	\$10.40/pcs	\$31.20
Grand Total:											\$627.70

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/24/18 7:06 AM dart.belanger.natasha



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916602

Date: 23-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: D5046-047 ✓ Co-Pilot Collective Head Assem Black Anodize per MIL-A-8625F, Type II, Class 2, .000007-.0010" (.07 - 1 mils) Job: 24188	Rev: B	PO: PO041798 ✓ Line: 2
12 ea	Part: RBH9928-2 ✓ Trim Tab Bender Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 24189	Rev: K	PO: PO041798 ✓ Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>23/11/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

DAS
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